






*In the interest
for H. J. Co.,*

Revised plan

S. NOS. 220. ~~388~~. 222.

INSTRUCTION PROFILE
AND
DECK PLANS.

220 *Nagara Maru* 

222 **NARUTO MARU**

~~388 *Naga Maru*~~



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Lloyd's Register
Foundation

00 9570 - 00 9579 - 0029

日本郵船株式會社

一般構造圖

尺度 1 : 100

工事番號 S.220 388 222

橫濱船渠株式會社
設計課

課長



係長

Handwritten signature

係員

製圖

Handwritten signature

同年月日

昭和 年 月 日

出圖

類別番號

H.202

圖面番號

2.100 x 810

GEN. BOX NO

520

3

設船二二〇協第五號

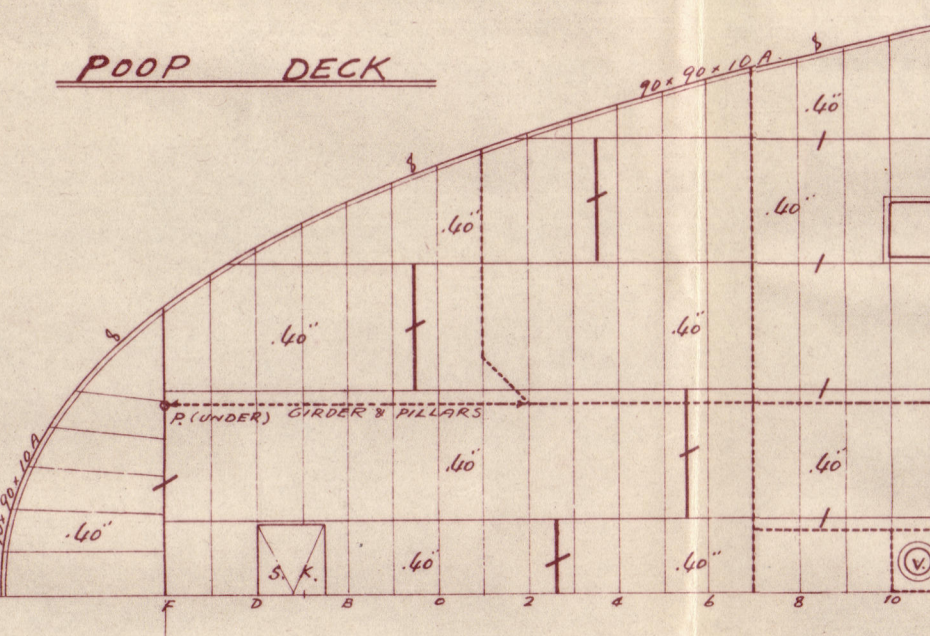
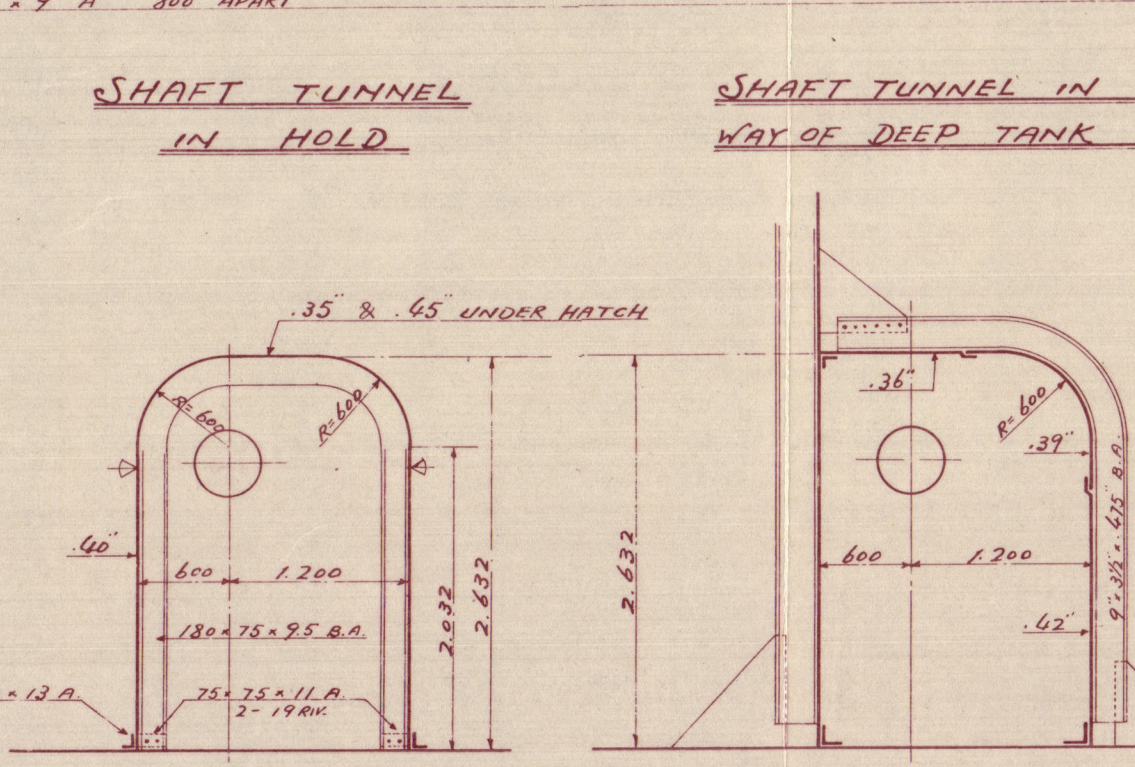
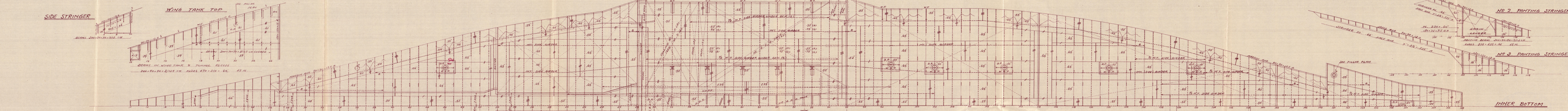
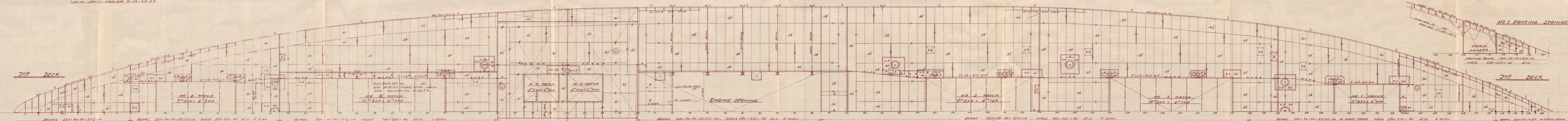
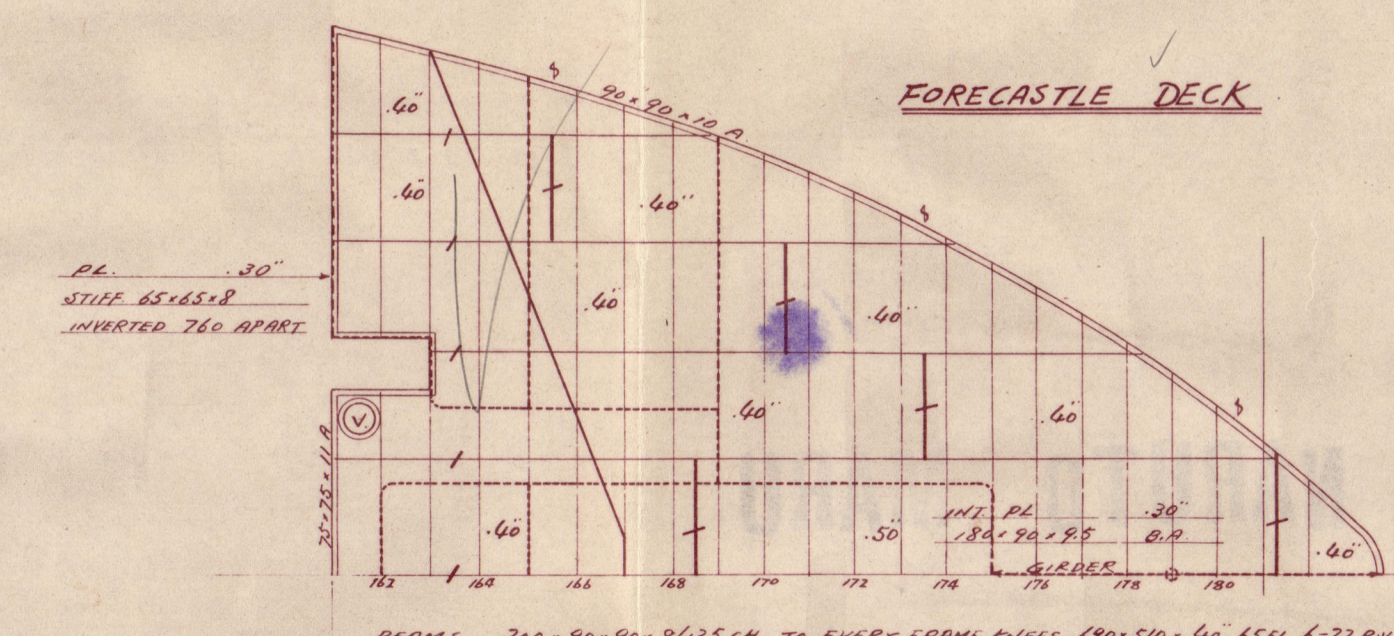
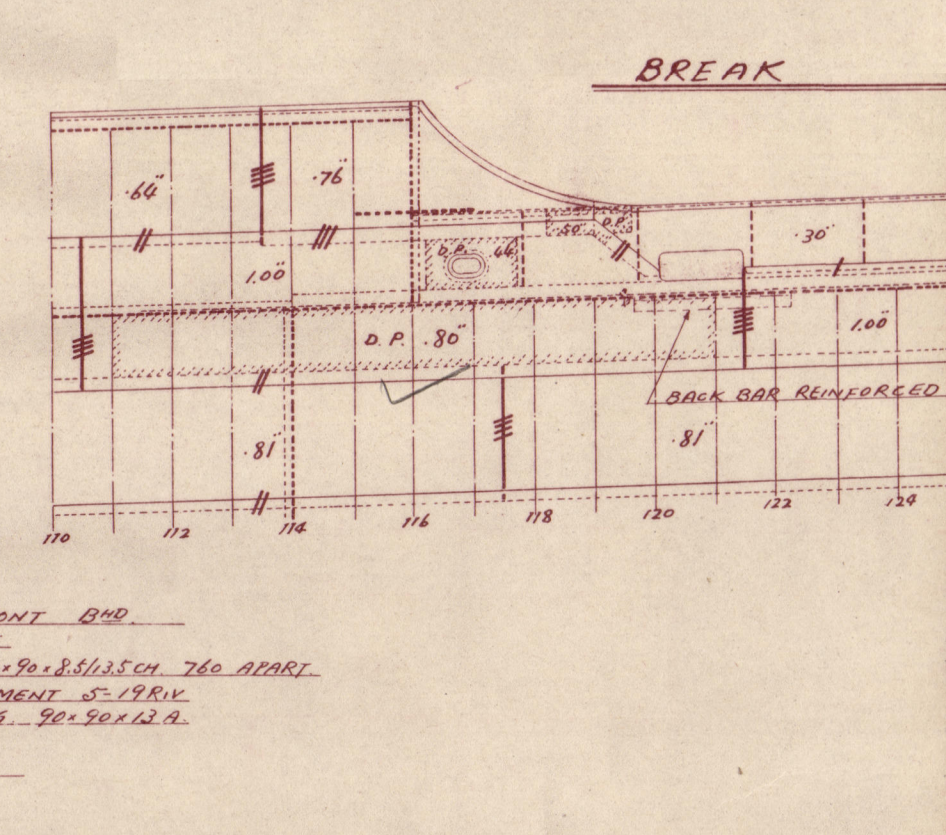


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CARGO HATCH.

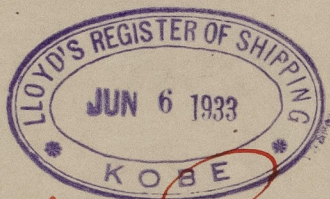
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5.220 388 22
廣船渠株式會社
設 計 課
H. 202
昭和 年 月
H. 202
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①

GEAR BOX NO 520

APPROVED



*In the name
for H.J. Cox*

220 Nagara Maru

222 **NARUTO MARU**

~~388 Nara Maru~~

Revised plan

S. NOS. 220. ~~388~~. 222

MIDSHIP SECTION

SCALE 1 : 25

009570 - 009579 - 0023



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Foundation

009570 - 009579 - 0023

中央橫斷面圖

尺度	1 : 25
工事 番號	S.220-388-222.
橫濱船渠株式會社 設計課	
課長	<i>[Signature]</i>
係長	<i>[Signature]</i>
係員	<i>[Signature]</i>
製圖	
同年月日	昭和 年 月 日
出圖	昭和 年 月 日
類別 番號	H.201
面番 番號	浜 H 822

設船二二〇協第五號



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"NAGARA MARU" (YARD. NO. S. 220.)

"NARUTO MARU" (" NO. S. 222.)

MID SHIP SECTION.

Scale. 1 : 25.

中央横断面圖

第二百拾、二拾番船

長良丸、鳴門丸

尺度二十五分の一



74491009

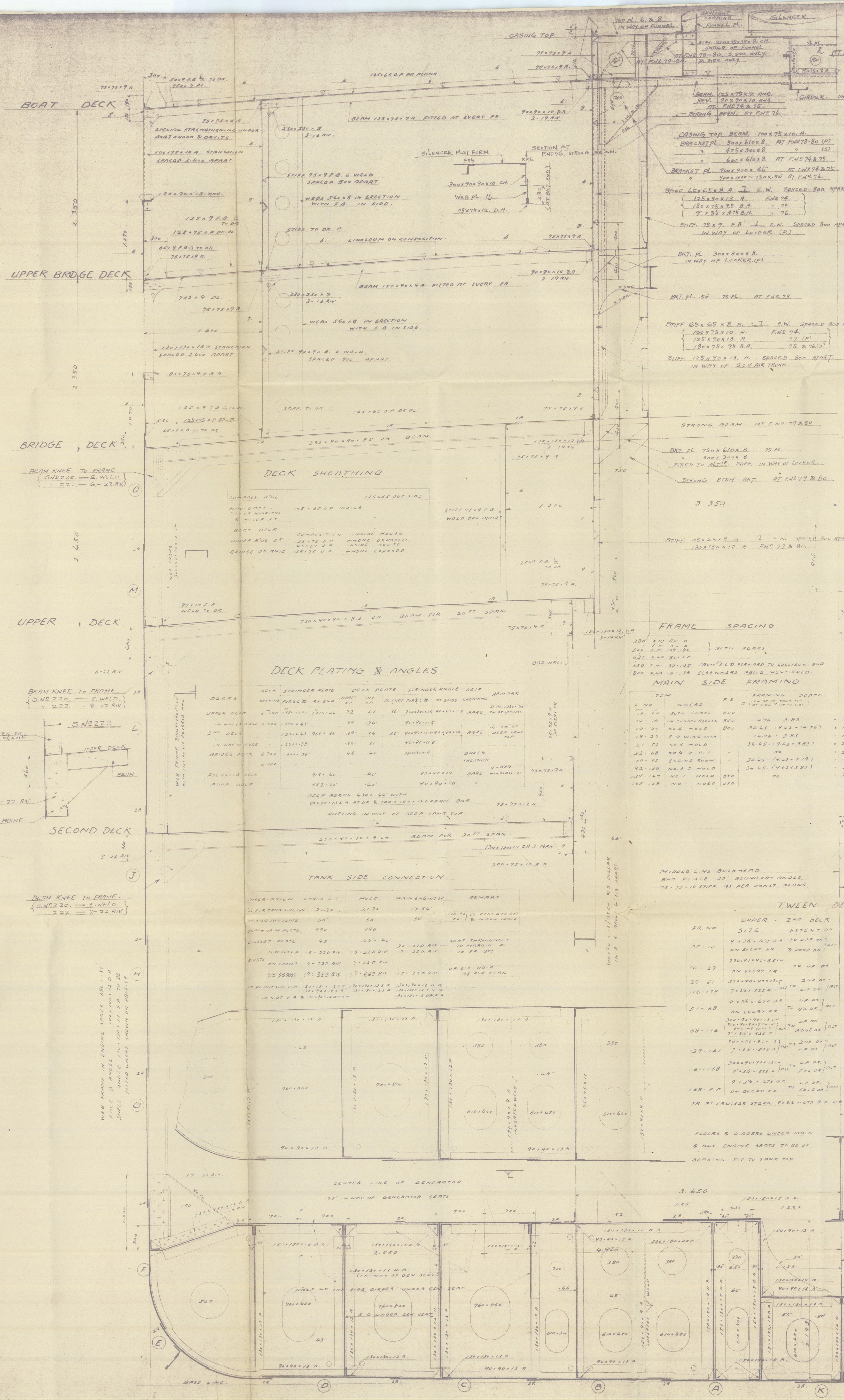
A.K.

007352-007362-0001



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MIDSHIP SECTION

SCALE 1/25

PRINCIPAL DIMENSIONS.		EQUIPMENT	
LENGTH OVERALL (EXCLUDING BOW OVER HANG)	141.520	L x (B.O.)	46.622 (47.36 x 30.85) = 63.187.63
LENGTH BETWEEN P.P.	136.000	FLG	60.50 x 7.55 x 7.5 = 1.239.70
BREADTH MLD.	19.000	BRIDGE	73.26 x 8.06 x 7.5 = 1.084.66
DEPTH MLD. TO UPPER DECK	10.500	POOP	23.35 x 7.55 x 7.5 = 1.311.56
LOAD DRAUGHT MLD.	8.335	DECK HOUSES	24.675 x 7.71 x 5.0 = 788.23
SHEAR AT UPPER DECK FORWARD	2.705	EQUIPMENT NUMBER	68.386.82
" " " " " " " "	1.400		
CAMBER OF SECOND DECK	150		
" " " " " " " "	300		
TWEEN DECK HEIGHT 2ND TO UPPER DECK (AT CENTRE)	1.100		
" " " " " " " "	2.450		
" " " " " " " "	2.300		

LIST OF EQUIPMENTS	
3. BOWER ANCHORS STOCKLESS (EACH)	77.35
1. STREAM ANCHOR (ON STOCK)	22.00
300# 2 1/2" STUD CHAIN CABLE FOR BOWER ANCHORS	
1. 12" 1/2" 6.25 SPECIAL FLEXIBLE STEEL WIRE ROPE FOR STREAM ANCHOR	TON LINE
1. 12" 1/2" 5.6.25	
3. 100# 3.1.12 FLEXIBLE STEEL WIRE ROPE FOR HAWKERS	WASPE
2. 100# 2.4.6.12	
4. 125# 1/2" 6.25 FOR WARRS.	

FORGING & CASTING	
STEM UPPER PORTION MILD STEEL PLATE & LOWER PORTION FORGED BAR	AS PER PLAN
STERN FRAME	LAST STEEL AS PER DETAIL PLAN
RUDDER	SIMPLEX BALANCED STREAM LINE RUDDER AS PER DETAIL PLAN

NOTE

ALL BULB ANGLES & CHANNELS TO BE OF YAWATA STANDARDS EACH MAY BE REPLACED BY ITS EQUIVALENT

S.N. 222

BRACKET OF PILLAR HEAD

BRIDGE & 2ND DECK, SIMILAR

SCANTLING NUMERALS

(FEET UNITS)

ITEM	SCANTLING	REMARKS
D	36.45	
L x D	66.32 x 36.45 = 5.372.38	
L x (B.O.)	66.32 x (63.36 + 36.45) = 43.189.63	
L/D TO UPPER DECK	66.32 / 36.45 = 1.82	
" " BRIDGE DECK	66.32 / 42.49 = 1.56	

(FOR FRAMING) SEE TABLE OF MAIN SIDE FRAMING BELOW.

FRAME SPACING

ITEM	FRAME	DEPTH	REMARKS
2. NO. 10	200	10.00	BOTH PEAKS
3. NO. 10	180	10.00	BOTH PEAKS
4. NO. 10	160	10.00	BOTH PEAKS
5. NO. 10	140	10.00	BOTH PEAKS
6. NO. 10	120	10.00	BOTH PEAKS
7. NO. 10	100	10.00	BOTH PEAKS
8. NO. 10	80	10.00	BOTH PEAKS
9. NO. 10	60	10.00	BOTH PEAKS
10. NO. 10	40	10.00	BOTH PEAKS
11. NO. 10	20	10.00	BOTH PEAKS

DECK PLATING & ANGLES

ITEM	DECK	PLATING	REMARKS
1. NO. 10	200	10.00	BOTH PEAKS
2. NO. 10	180	10.00	BOTH PEAKS
3. NO. 10	160	10.00	BOTH PEAKS
4. NO. 10	140	10.00	BOTH PEAKS
5. NO. 10	120	10.00	BOTH PEAKS
6. NO. 10	100	10.00	BOTH PEAKS
7. NO. 10	80	10.00	BOTH PEAKS
8. NO. 10	60	10.00	BOTH PEAKS
9. NO. 10	40	10.00	BOTH PEAKS
10. NO. 10	20	10.00	BOTH PEAKS

TANK SIDE CONNECTION

ITEM	TANK	SIDE	CONNECTION	REMARKS
1. NO. 10	200	10.00	BOTH PEAKS	
2. NO. 10	180	10.00	BOTH PEAKS	
3. NO. 10	160	10.00	BOTH PEAKS	
4. NO. 10	140	10.00	BOTH PEAKS	
5. NO. 10	120	10.00	BOTH PEAKS	
6. NO. 10	100	10.00	BOTH PEAKS	
7. NO. 10	80	10.00	BOTH PEAKS	
8. NO. 10	60	10.00	BOTH PEAKS	
9. NO. 10	40	10.00	BOTH PEAKS	
10. NO. 10	20	10.00	BOTH PEAKS	

TWEEN DECK FRAMES

ITEM	TWEEN	DECK	FRAMES	REMARKS
1. NO. 10	200	10.00	BOTH PEAKS	
2. NO. 10	180	10.00	BOTH PEAKS	
3. NO. 10	160	10.00	BOTH PEAKS	
4. NO. 10	140	10.00	BOTH PEAKS	
5. NO. 10	120	10.00	BOTH PEAKS	
6. NO. 10	100	10.00	BOTH PEAKS	
7. NO. 10	80	10.00	BOTH PEAKS	
8. NO. 10	60	10.00	BOTH PEAKS	
9. NO. 10	40	10.00	BOTH PEAKS	
10. NO. 10	20	10.00	BOTH PEAKS	

DOUBLE BOTTOM

ITEM	DOUBLE	BOTTOM	REMARKS
1. NO. 10	200	10.00	BOTH PEAKS
2. NO. 10	180	10.00	BOTH PEAKS
3. NO. 10	160	10.00	BOTH PEAKS
4. NO. 10	140	10.00	BOTH PEAKS
5. NO. 10	120	10.00	BOTH PEAKS
6. NO. 10	100	10.00	BOTH PEAKS
7. NO. 10	80	10.00	BOTH PEAKS
8. NO. 10	60	10.00	BOTH PEAKS
9. NO. 10	40	10.00	BOTH PEAKS
10. NO. 10	20	10.00	BOTH PEAKS

BRACKET FLOOR

ITEM	BRACKET	FLOOR	REMARKS
1. NO. 10	200	10.00	BOTH PEAKS
2. NO. 10	180	10.00	BOTH PEAKS
3. NO. 10	160	10.00	BOTH PEAKS
4. NO. 10	140	10.00	BOTH PEAKS
5. NO. 10	120	10.00	BOTH PEAKS
6. NO. 10	100	10.00	BOTH PEAKS
7. NO. 10	80	10.00	BOTH PEAKS
8. NO. 10	60	10.00	BOTH PEAKS
9. NO. 10	40	10.00	BOTH PEAKS
10. NO. 10	20	10.00	BOTH PEAKS

WELDING NOTE

△ BUTT WELD

△ INTERMITTENT WELD

△ INTERMITTENT WELD AT BOTH SIDES

△ CONTINUOUS WELD

ALL ELECTRIC WELDING IS SUBJECT TO OWNERS SANCTION AND TO RULE REQUIREMENTS BEING FULLY COMPLIANT WITH

"NAGARA MARU" (YARD NO. 220)
"HARUTO MARU" (YARD NO. 222)
MIDSHIP SECTION
Scale 1:25

中央横断面図



日本郵船株式會社

船尾骨棧及舵

STERN FRAME
& RUDDER

尺度	1 : 25 1 : 10
工事番号	S. 220-222

横濱船渠株式會社
設計課

課長	
係長	M. Murata
係員	
製図	海上
年月日	昭和8年3月25日
出図	
類別番号	H 211
図面番号	洪H845.

1,230 x 800

(18)

ロイド

GEN BOX No 108

220 Koruto Maru

222 NARUTO MARU



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Lloyd's Register
Foundation

009570-009579-0022

號 上 仕 上

S. 220-222

舵軸受金具

尺度 1/5

RUDDER
GUIDE BEARING

御承認用



貯

監査	検査	
外註	船材	計

009570-009579-0020

14

ロイド

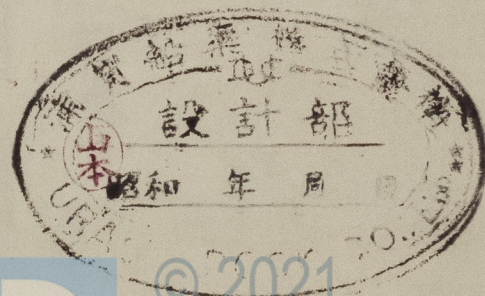
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M/M 9570

'NAGARA MARU'

Nagara Maru

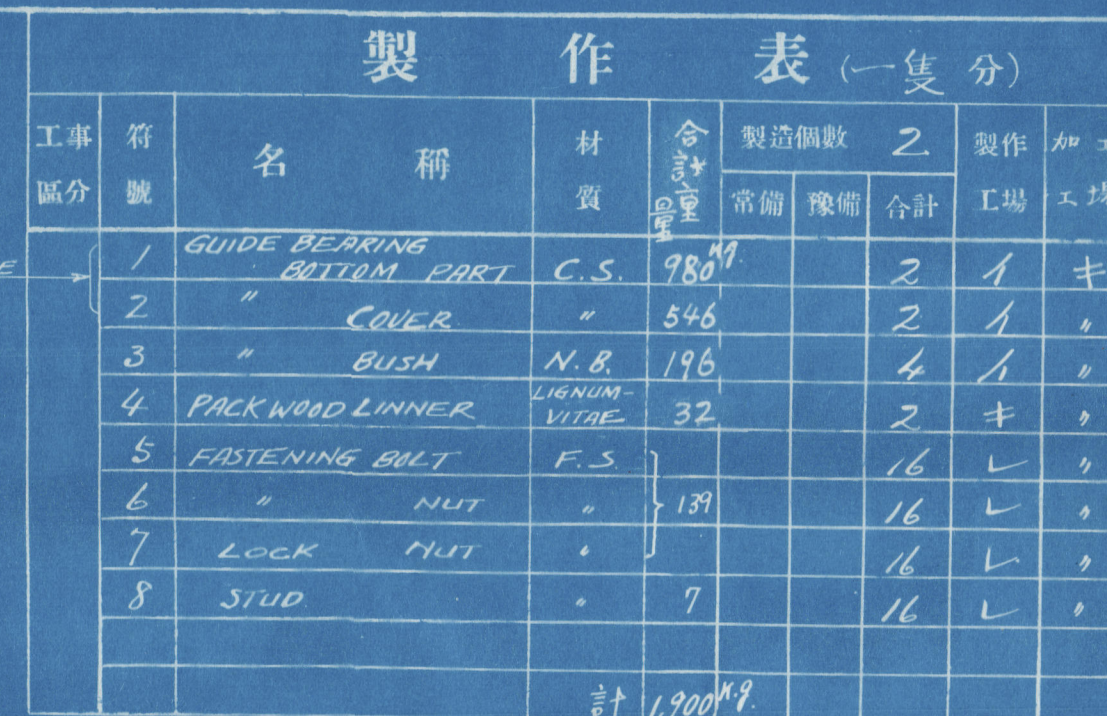
NARUTO MARU



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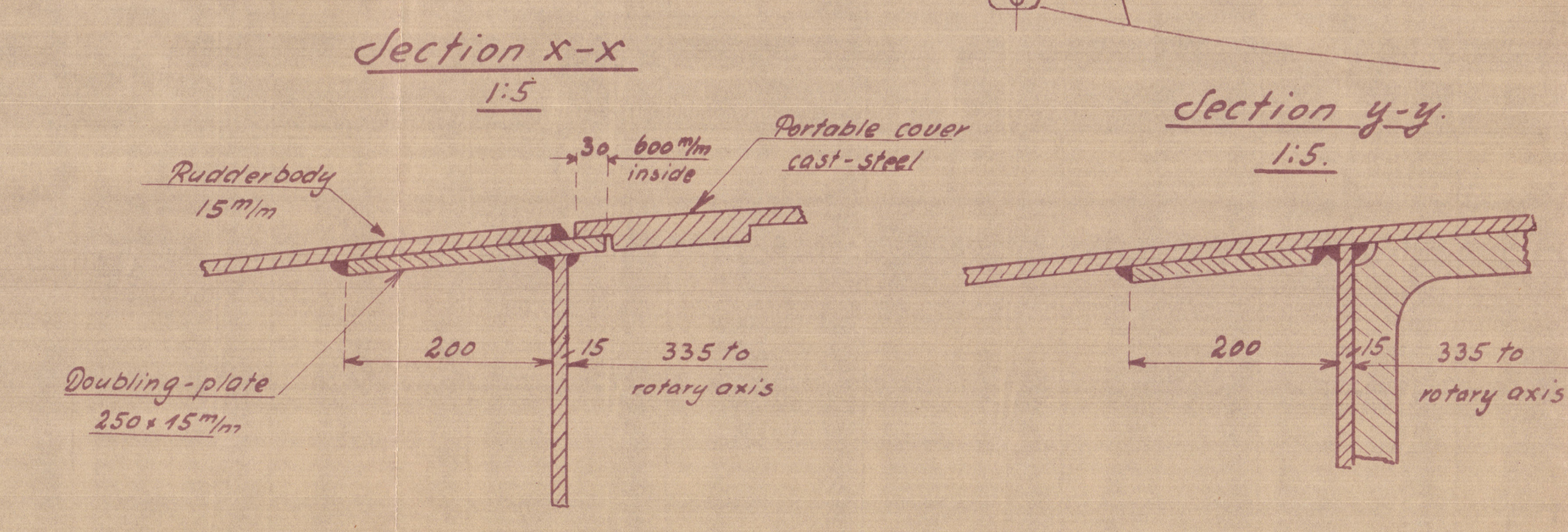
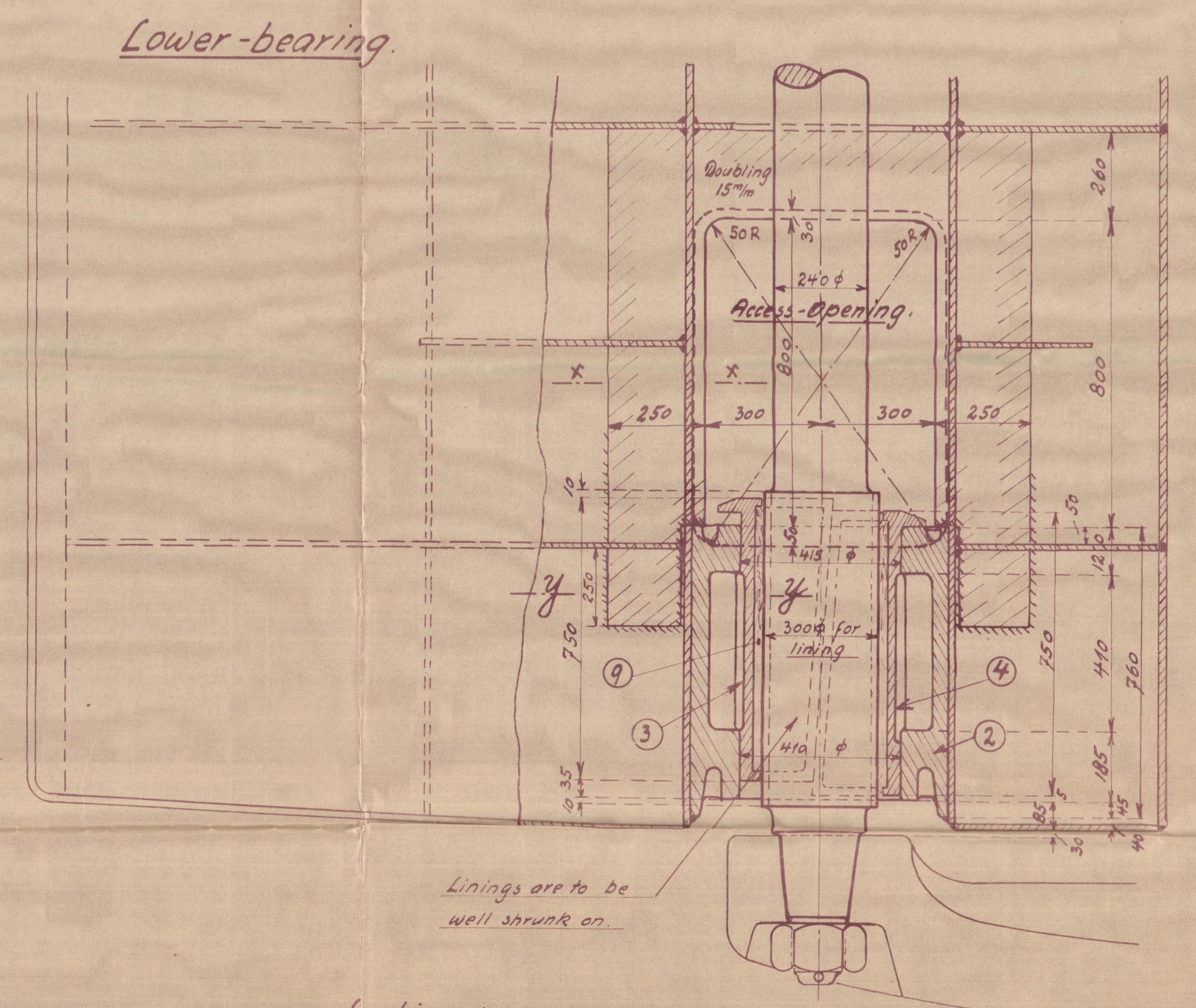
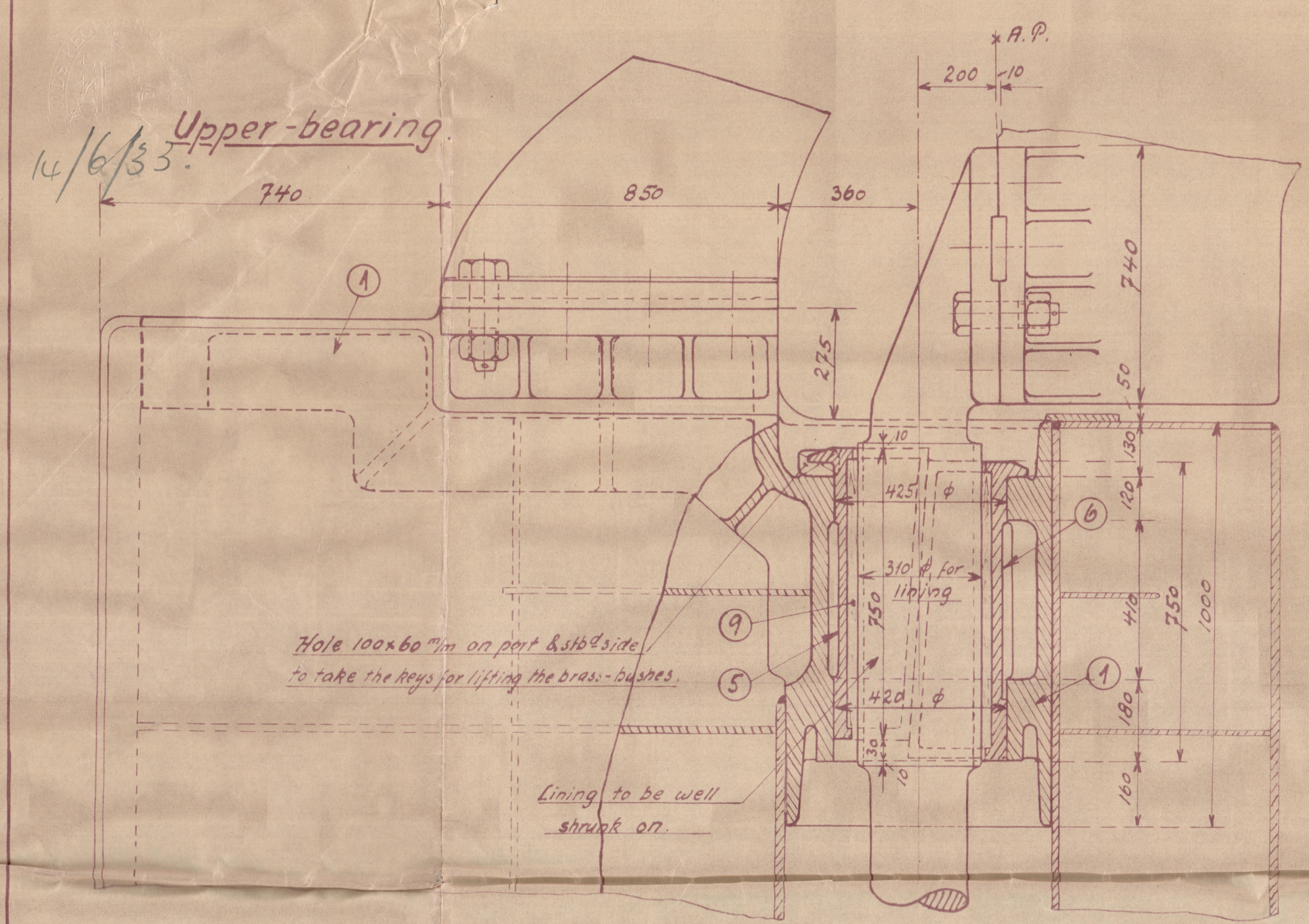
Lloyd's Register
Foundation

009570-009579-0020

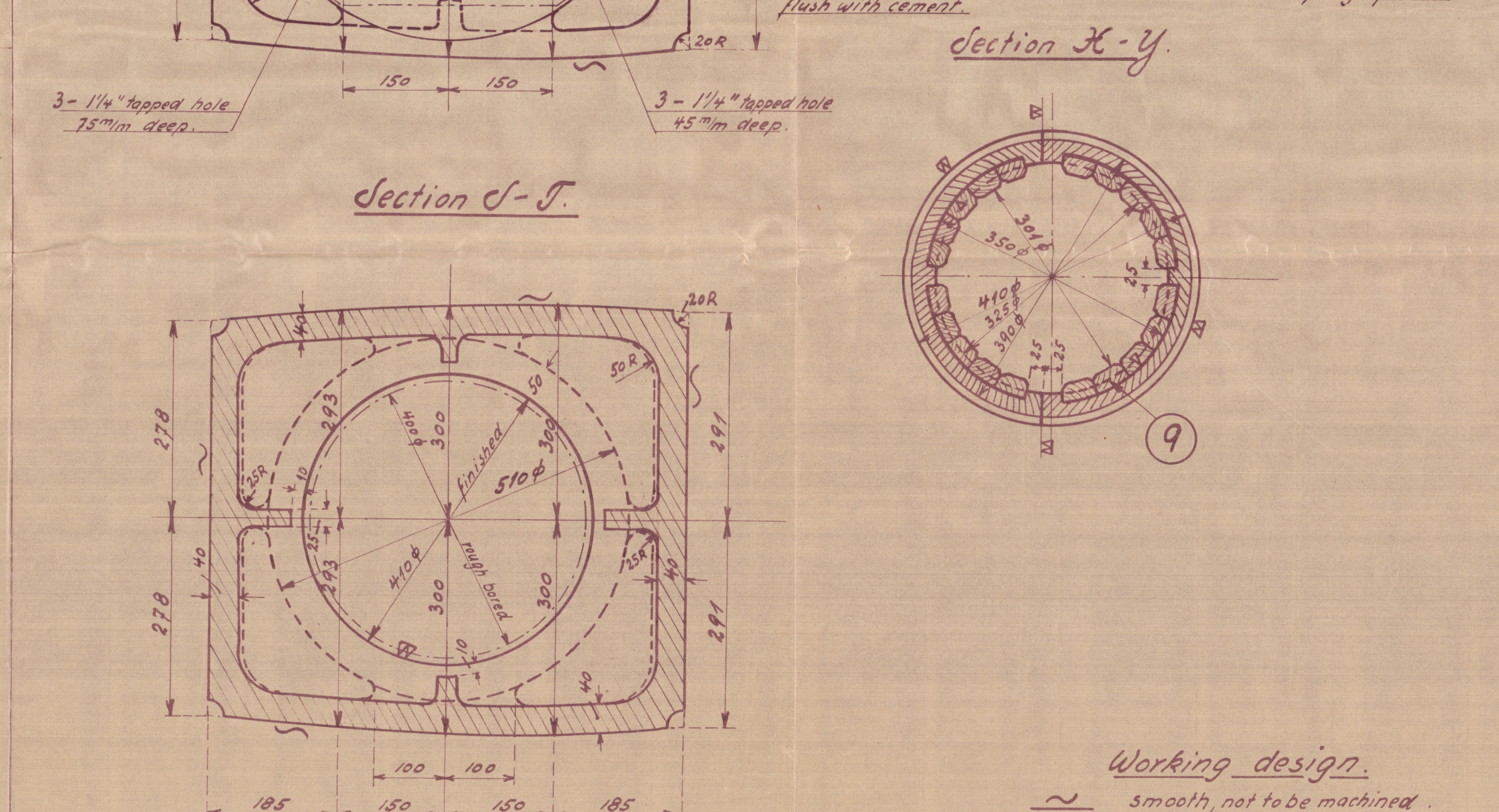
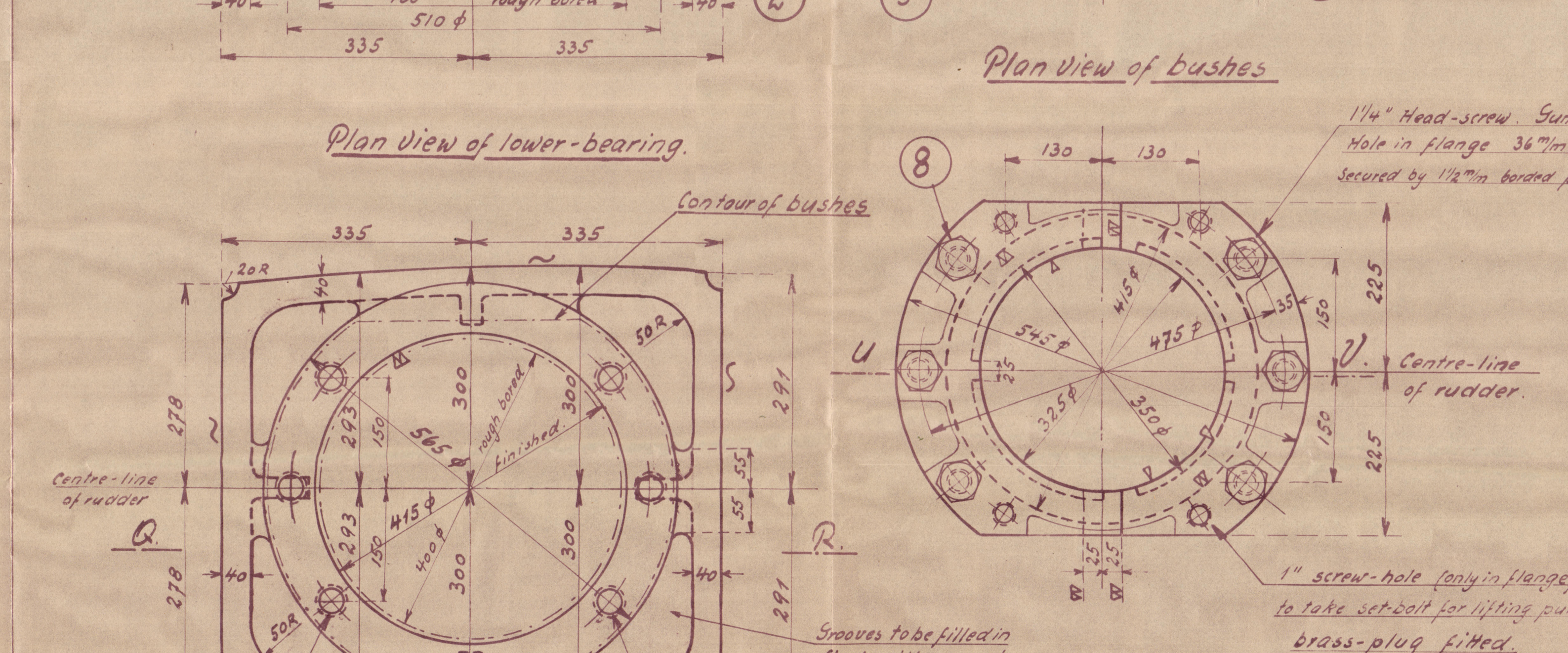
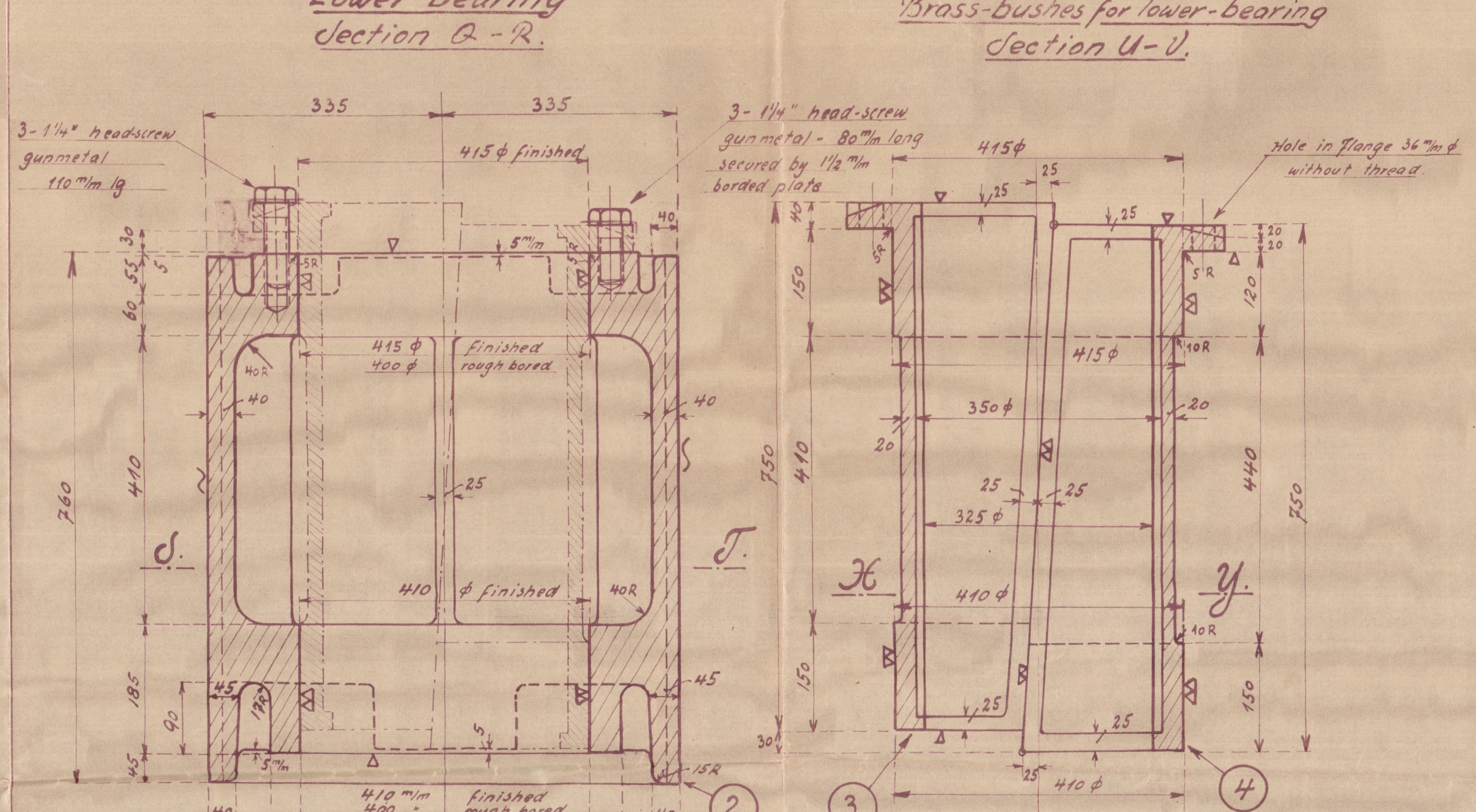
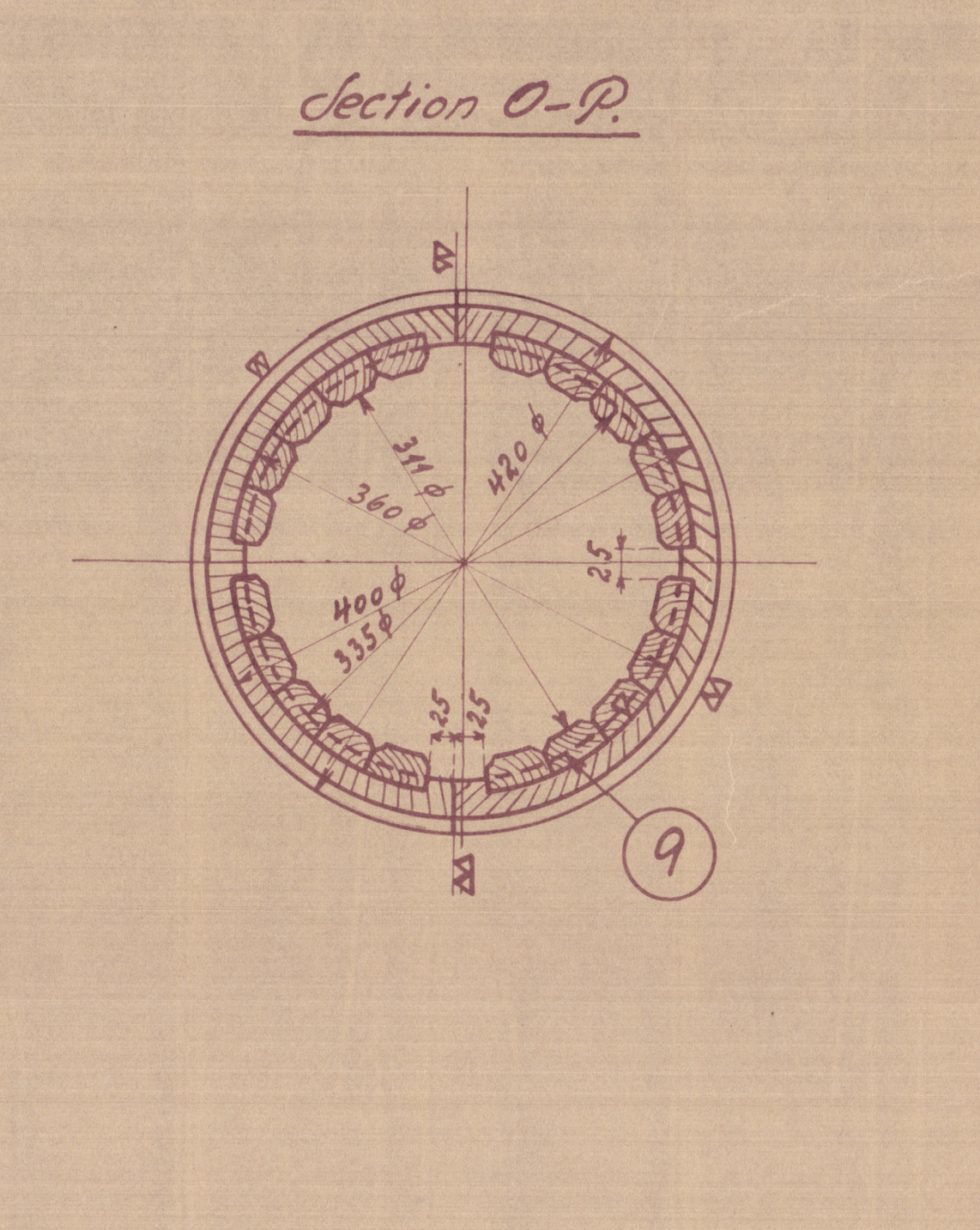
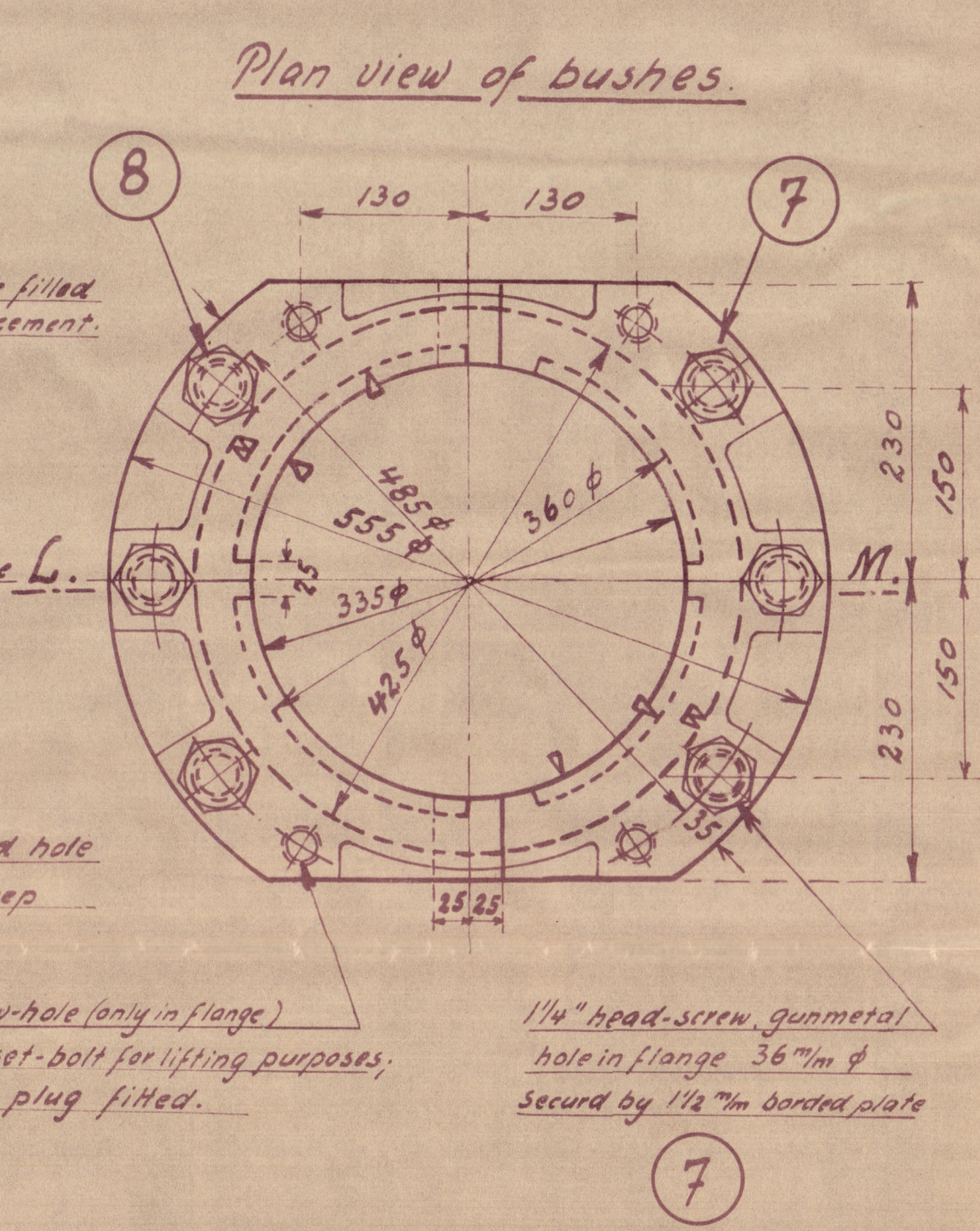
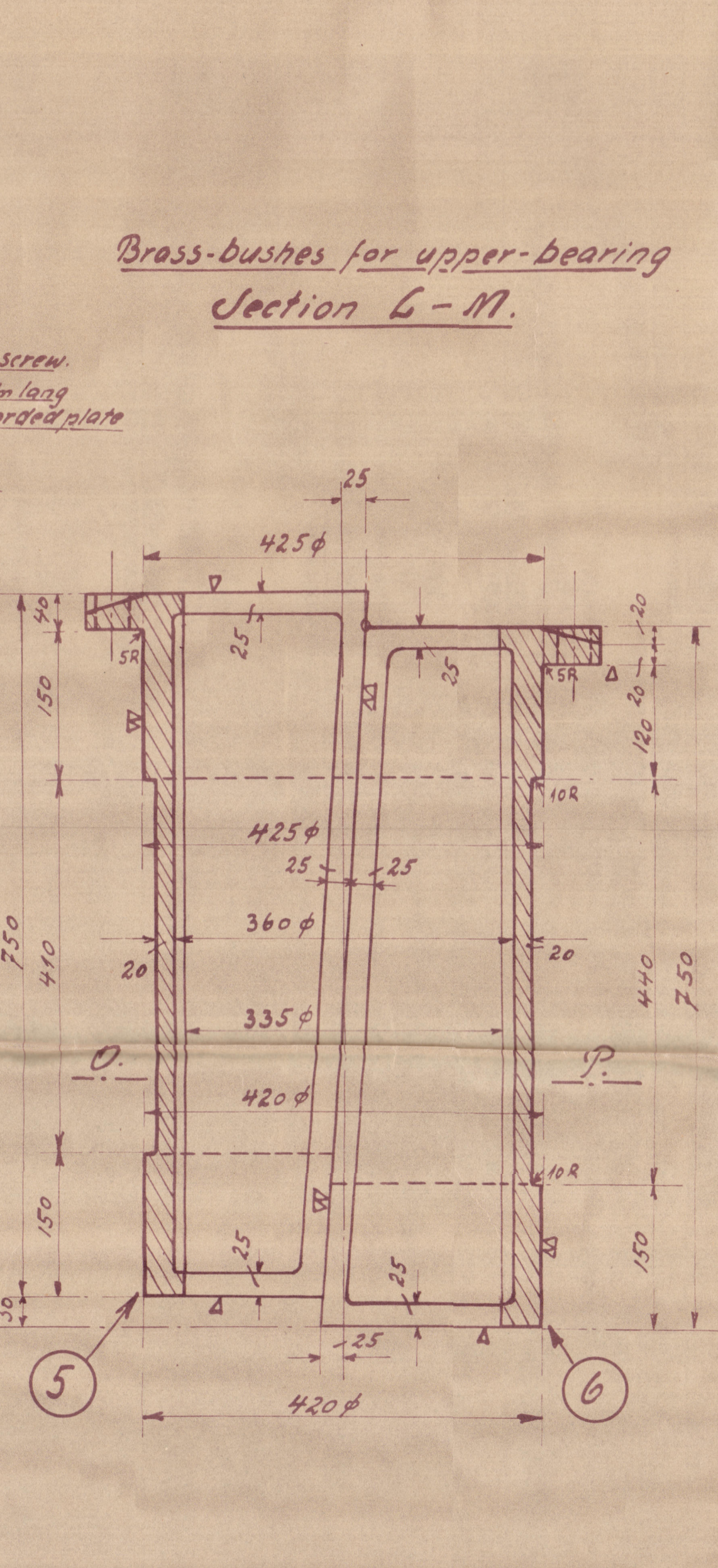
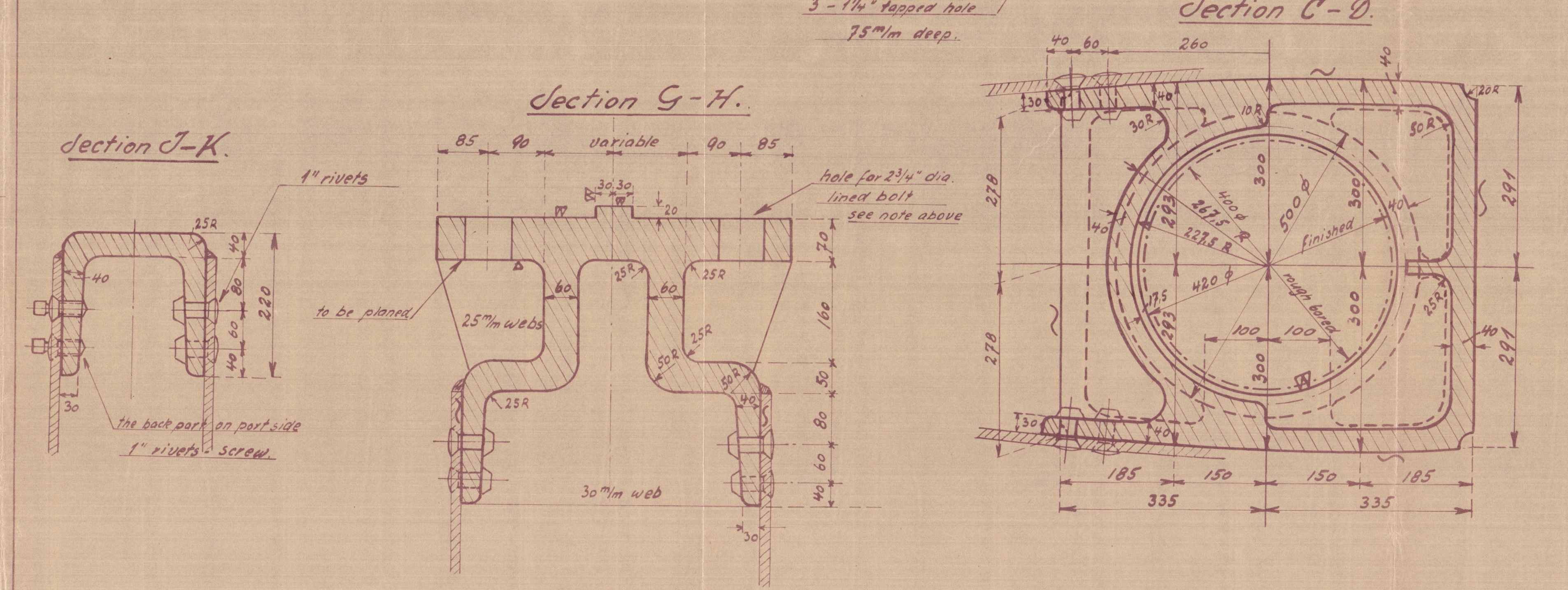
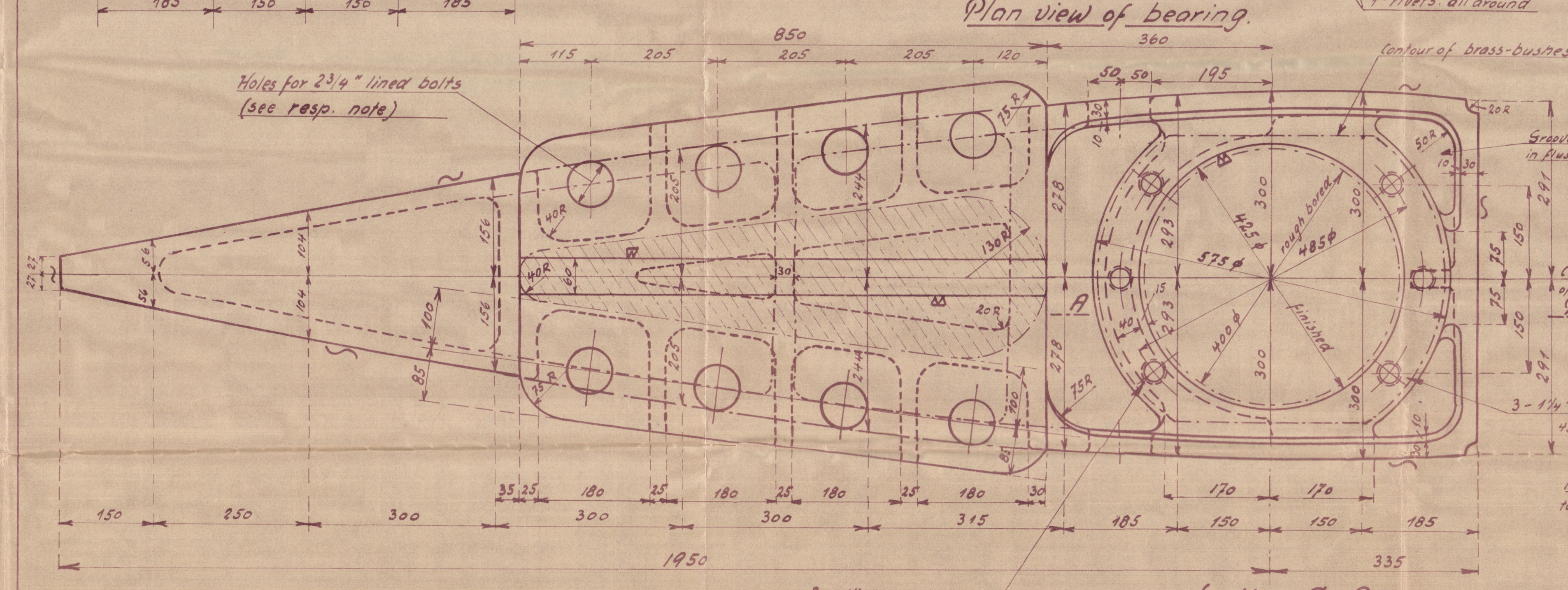
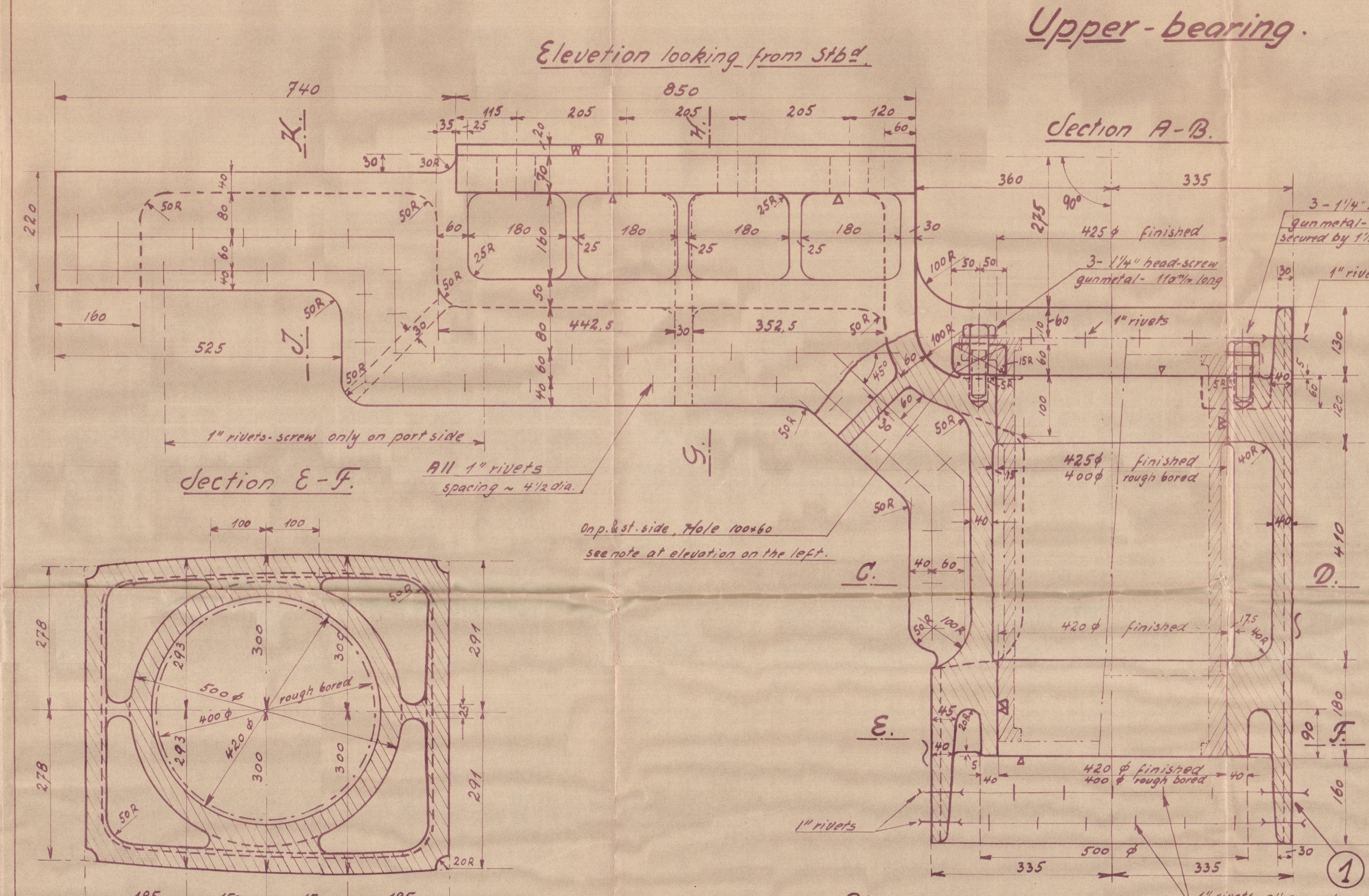


製造數貳組壹隻分

009570-009579-0020



Arrangement 1:10, 1:5.



Working design.

~ smooth, not to be machined.

▽ roughly machined

□ perfectly

Notes.

- The inside diameters of the rudder-bearings are to be exactly machined after the rudder-body has been ready welded in all parts and the bearings have been fitted in place.
- The holes for the lined-coupling bolts in upper-bearing are to be exactly machined in accordance to coupling of rudder-head after the two rudder-bearings have been placed in perfectly straight line to centerline of rudder-head.
- The brass-bushes are to be jointed carefully with fat.

GEN. BOX NO 520

Materials: Responding to Japanese Government-Rule and to Lloyd's Register of Shipping.

220 Nagara Maru 222 Notochi Maru

No.	Part	Material	Quantity	Remarks
2	Bushes	ligum vitae		
6	Head-screw 1 1/4" thread	gunmetal	440 mm long	
6	Head-screw 1 1/4" thread	gunmetal	80	
1	Brass-bushes half upper			
1	Brass-bushes half lower			
1	Lower-bearing	Cast-steel		
1	Upper-bearing a coupling piece			

Weight 0.00.

Alteration

for "NAGARA MARU" No. 9570

for "Complex" Balance Rudder

14.6.33

14.6.33